Date:

Thursday, 10/08/2006 10:03:58 AM

User: Linda Lacelle

Process Sheet

Customer

First Issue

: CU-DAR001 Dart Helicopters Services

Drawing Name

: BASKET LID ASSEMBLY

Job Number **Estimate Number**

: 28140A : 10206

P.O. Number

: NIA

S.O. No. : 12/14 : 10/08/2006

This Issue Prsht Rev. : NC

: NIP

: LARGE FAB ASSY

: 27130 **Previous Run**

Written By

Checked & Approved By

Comment

: Est Rev:L

Removed D2989-043.

Part Number Drawing Number

: D2989041 D2989 REV B : N/A

Project Number Drawing Revision

Material **Due Date**

AIG: : 31/08/2006

Qty:

1 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

JLM

1.0

2.0

3.0

D31663

Basket Hoop



Comment: Qty.:

1.0000 Each(s)/Unit Total:

1.0000 Each(s)

Pick:

Qty.(1) D3166-3

Batch: <u>B</u> 28095

Mounting Bracket

Comment: Qtv.:

D2581

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Pick:

. Qty Part number

Description Batch

2 D2581

Mounting Brackets 827524

D23273

Spacer Bushing



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2327-3

Bushing

D2506

4.0

Placard

Comment: Qty.:

1.0000 Each(s)/Unit Total:

1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D2506

Label Plate A 26631-2

100/08/10 C

Dart Ae	rospace	Ltd								
W /O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cated	_ NCR: Yes	NCR: Yes No DQA: Date:					
								Date: _		
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NC	R)				
DATE	STEP	Description of NC	Corrective Action Section B			Verifi	fication	Approval	Approval	
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	Section C	Chief Eng	QC Inspector	
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Tate & initial all entries

Thursday, 10/08/2006 10:03:58 AM Linda Lacelle User: **Process Sheet Drawing Name: BASKET LID ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Part Number: D2989041 Job Number: 28140A Job Number: Description: Seq. #: **Machine Or Operation:** M304EX07516F **Expanded Metal Flat Stai** 5.0 Comment: Qty... 15.0000 sf(s)/Unit Total: 15.0000 sf(s) Pick: Description Batch Qty Part number Expanded Metal M101707 15sf M304EX0.75-16F .304 SQ Tube.75x.75x.065W 6.0 31.7709 f(s)/Unit Total: Comment: Qty.: 31.7709 f(s) 3/4" x 3/4" x 0.063" wall 304/316 SStubing Batch: (MA) (MI) 1359 7.0 LARGE FAB **Comment: LARGE FABRICATION RESOURCE 1** 1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989 2-Drill holes in tubing as D2989-041 per Dwg D2989 3-Deburr and remove all markings on material 4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid 1180/08/16 @ 5-Drill Ø0.257" hole as D2989-041 per Dwg D2989Identify as D2989-041 DDIMENSIONAL & WELDING INSPECTION 8.0 QC9/6 Comment: DDIMENSIONAL & WELDING INSPECTION POWDER COATING 9.0 **Comment: POWDER COATING** 06.08-24 1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989 2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Page 2

Spray Paint Black: M10193? Wing Walk: M101266

93

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A: <u></u>	P Date: _(108/30			
				V/C Close						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC	Corrective Action Section B			Varification				
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 28140A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: Inspect Powder Coat and Wing Walk



11.0

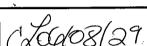
DC

DOCUMENT CONTROL



Comment: DOCUMENT

Inspection Level 21



Job Completion



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W/O:			WO	RK ORDER CHANGI	ES				
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	(1)			
DATE	STEP	Description of NC		n B	Verification Appro		Approval	val Approval	
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries